

Work Order ID 73610

Wednesday, September 07, 2011 1:34:25 PM



Page 1

Item ID: D412-630-031

Accept



Setup Start



Revision ID:

Stop



Item Name: Pilot/Co-Pilot Step. LH (Folding)

Start Date: 9/14/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 9/23/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN D412-630

Rev M

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D412-630 bluefile & type labels per PPP412-630-031 CHG003

5 12/01/14

MLJ 12-1-9 (2)

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D412-630 p.17

****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****

12/01/09 (2)

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

****ensure tension to retract step is 11 to 18 lbs ****

5 12/01/09

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, September 07, 2011 1:34:21 PM

Page 1

Work Order ID: 73610

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)



Start Date: 9/14/2011

Required Date: 9/23/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV. A 05.11.21 NEW ISSUE EC
IPP REV. B 05.12.19 updated pick list EC
IPP REV. C 07.11.12 ecn 1019,no chg EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN310-4

Purchased

No

130

Each

34.0000

1

3

M119320



NUT

Location

Loc Qty

Loc Code

ST324

34

118112

34

AN310-5

Purchased

No

130

Each

34.0000

2

4



NUT

Location

Loc Qty

Loc Code

ST324

34

114830

4

118112

30

AN3C5A

Purchased

No

130

Each

1,259.000

3

6

12/1/95

20



Bolt

Location

Loc Qty

Loc Code

FP-A

7

115835

7

ST350

1252

116419

28

116549

30

117343

462

117764

222

117872

10

118451

500

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 73610

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 9/14/2011

Required Date: 9/23/2011

Start Qty: 2.00

Required Qty: 2.00

AN44-C12

Purchased

No

130

Each

15.0000

1



eyebolt

Location

Loc Qty

Loc Code

ST362

15

117616

15

130

Each

24.0000

1

AN4C15

Purchased

No



BOLT

Location

Loc Qty

Loc Code

ST358

24

118091

9

118652

15

130

Each

25.0000

1

AN5C11

Purchased

No



BOLT

Location

Loc Qty

Loc Code

ST337

25

114801

25

130

Each

19.0000

1

AN5C15

Purchased

No



BOLT

Location

Loc Qty

Loc Code

ST338

19

117616

19

130

Each

23.0000

1

AN960C516

Purchased

No



WASHER

Location

Loc Qty

Loc Code

ST347

23

102842

23

Wednesday, September 07, 2011 1:34:22 PM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

Wednesday, September 07, 2011 1:34:22 PM

Work Order ID: 73610

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 9/14/2011

Required Date: 9/23/2011

Start Qty: 2.00

Required Qty: 2.00

S₂ D3454-1
Bushing

Manufactured No

130 Each

12.0000

1

2

Location

Loc Qty

Loc Code

ST054

12

58555

12

130 Each

14.0000

2

4

S₂ D3454-3
Bushing

Manufactured No

Location

Loc Qty

Loc Code

ST058

14

68467

14

130 Each

16.0000

2

4

S₂ D3454-5
Bushing

Manufactured No

Location

Loc Qty

Loc Code

ST054

16

70527

16

130 Each

29.0000

4

8

S₂ D3455-1
Spacer

Manufactured No

Location

Loc Qty

Loc Code

ST054

1

68469

1

ST058

28

72133

28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 73610

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 9/14/2011

Required Date: 9/23/2011

Start Qty: 2.00

Required Qty: 2.00

D3455-3

Manufactured No

130

Each

28.0000

2

4



Spacer

Location

Loc Qty

Loc Code

ST054

28

68470

5

72163

23

4

D3462-041

Manufactured No

130

Each

4.0000

1

2



Bracket Assembly

041

Location

Loc Qty

Loc Code

ST198A

4

72030

4

MS21043-3

Purchased No

130

Each

1.333.000

3

6



Nut

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

1261

112314

6

118077

255

118614

500

118686

500

371703

1119901512

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, September 07, 2011 1:34:22 PM

Work Order ID: 73610

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 9/14/2011

Required Date: 9/23/2011

Start Qty: 2.00

Required Qty: 2.00

MS24665-227

Purchased

No

130

Each

96.0000

2

4



COTTER PIN

Location

Loc Qty

Loc Code

GA

90

111041

90

ST309

6

113845

6

MS24665-229

Purchased

No

130

Each

307.0000

2

4



COTTER PIN

Location

Loc Qty

Loc Code

GA

200

118234

200

ST309

107

111041

107

NAS1149C0363R

Purchased

No

130

Each

4,145.000

7

14



Washer

Location

Loc Qty

Loc Code

ST297

4145

114742

4145

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, September 07, 2011 1:34:22 PM

Work Order ID: 73610

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step. LH (Folding)

Start Date: 9/14/2011

Required Date: 9/23/2011

Start Qty: 2.00

Required Qty: 2.00

NAS1515H5

Purchased

No

130

Each

168.0000

1



Washer

Location

Loc Qty

Loc Code

FG

40

103286

20

103691

20

ST277

128

103286

100

118384

28

D3463-041

Manufactured

No

110

Each

0.0000

1



Step Weldment Assembly

D3443-043

Manufactured

No

110

Each

3.0000

1



Strut Weldment Assembly

Location

Loc Qty

Loc Code

ST198A

3

71030

3

D3443-041

Manufactured

No

110

Each

0.0000

1



Strut Weldment Assembly

D3443-9

Manufactured

No

110

Each

8.0000

2



Pin

Location

Loc Qty

Loc Code

ST054

8

72029

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

Wednesday, September 07, 2011 1:34:22 PM

Work Order ID: 73610

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 9/14/2011

Required Date: 9/23/2011

Start Qty: 2.00

Required Qty: 2.00

D3454-7
Bushing

Manufactured No

110 Each

14.0000

2 4



73346 2x

Location

Loc Qty

Loc Code

ST058

14

70528

14

70528 2x

D3455-1
Spacer

Manufactured No

110 Each

29.0000

2 4



73302

Location

Loc Qty

Loc Code

ST054

1

68469

1

ST058

28

72133

28

D3465-1
Washer

Manufactured No

110 Each

7.0000

1 2



73448 1x

Location

Loc Qty

Loc Code

ST054

7

46134

7

46134 1x

AN4CH3
SS Bolt

Purchased No

110 Each

40.0000

2 4



12/1/10

Location

Loc Qty

Loc Code

ST357

40

117616

1

118131

9

118757

10

118758

20

1x 818131

2x 118757

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, September 07, 2011 1:34:22 PM

Work Order ID: 73610

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 9/14/2011

Required Date: 9/23/2011

Start Qty: 2.00

Required Qty: 2.00

AN4C14 Purchased No 110 Each 28.0000
BOLT

Location	Loc Qty	Loc Code
ST357	25	
117688	25	
ST358	3	
114669	3	

1 2
117688

AN310-4 Purchased No 110 Each 34.0000
NUT

Location	Loc Qty	Loc Code
ST324	34	
118112	34	

1 2
119328

AN310-7 Purchased No 110 Each 30.0000
NUT

Location	Loc Qty	Loc Code
ST324	30	
114784	30	

1 2
114784

MS24665-227 Purchased No 110 Each 96.0000
COTTER PIN

Location	Loc Qty	Loc Code
GA	90	
111041	90	
ST309	6	
113845	6	

1 2
114784
114041
11/1/15 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, September 07, 2011 1:34:22 PM

Work Order ID: 73610

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)



Start Date: 9/14/2011

Required Date: 9/23/2011

Start Qty: 2.00

Required Qty: 2.00

MS24665-302

Purchased

No

110

Each

141.0000

1

2



Cotter Pin



C. 12/01/00 (2)

Location

Loc Qty

Loc Code

ST357

141

117460

141

117460

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

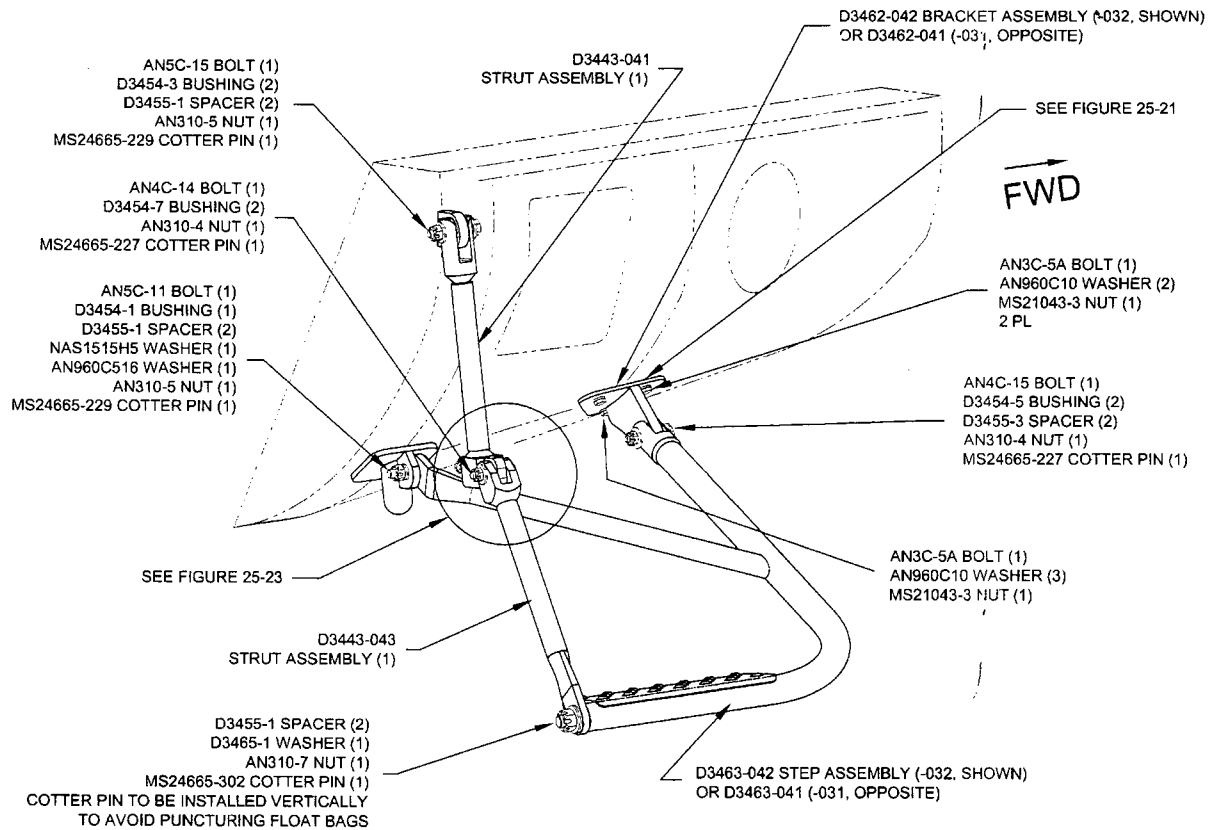


FIGURE 25-22: Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

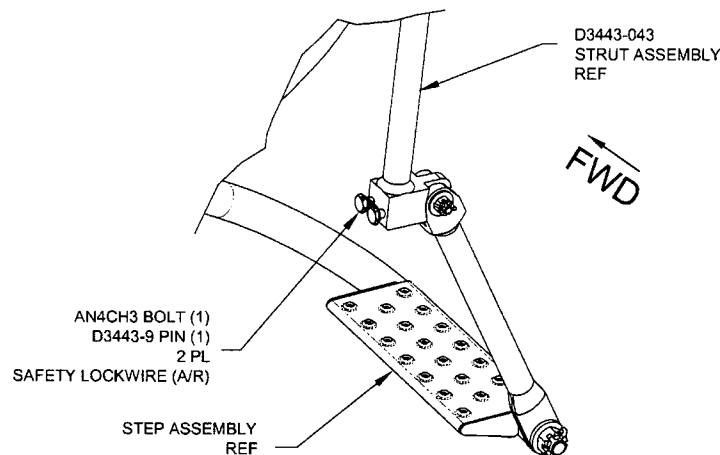


FIGURE 25-23: Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

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25-00-00

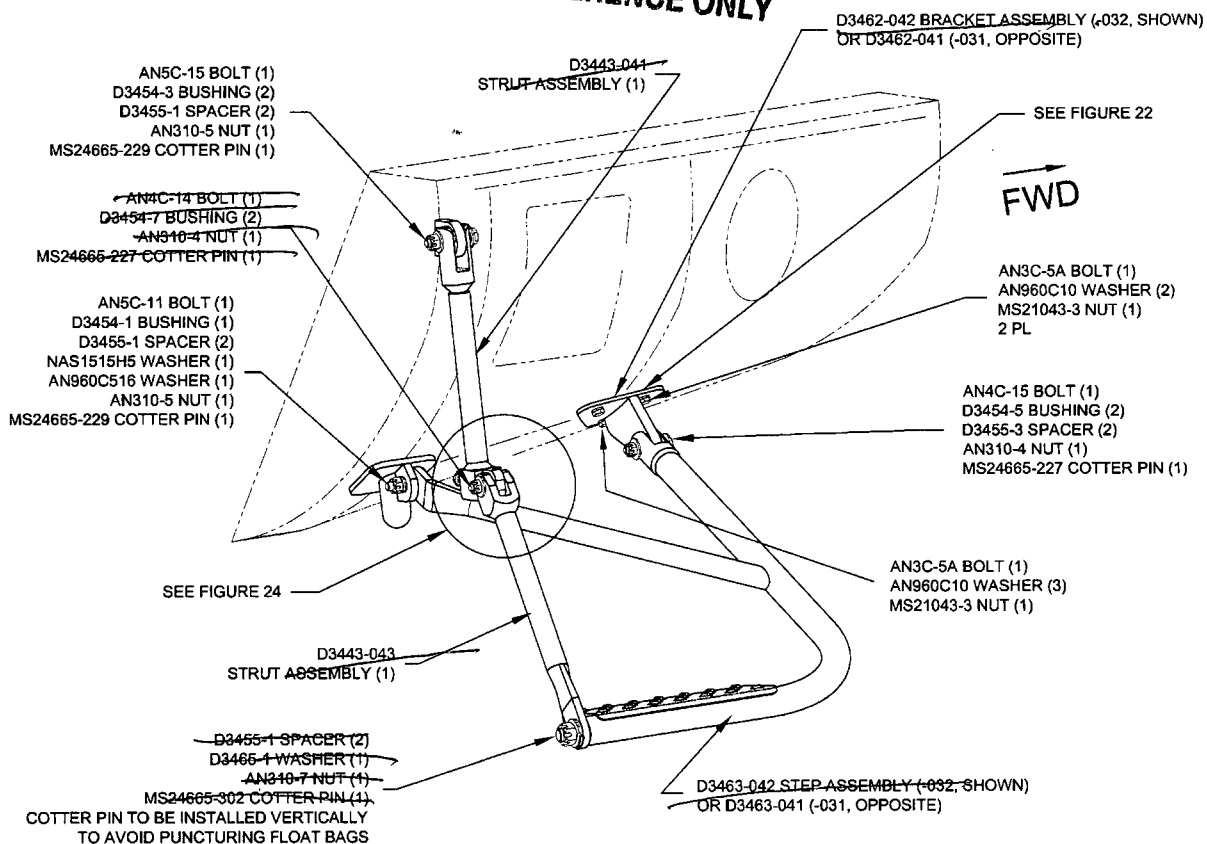
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

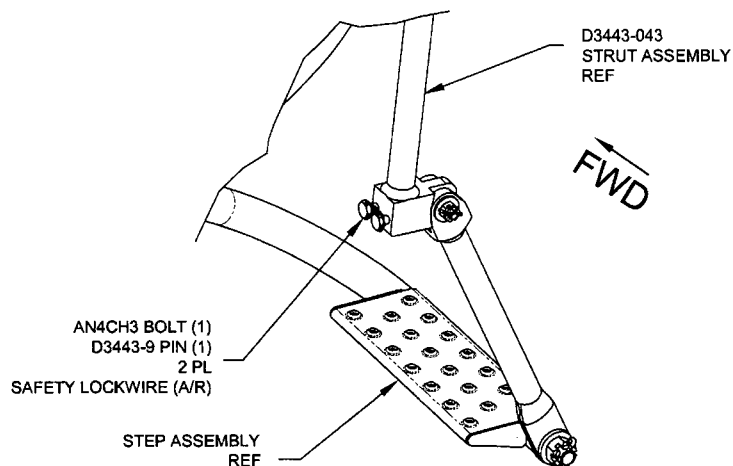
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8
REFERENCE ONLY

**FIGURE 23 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)**



**FIGURE 24 – Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)**

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Revision: **M**
Date: 08.12.12

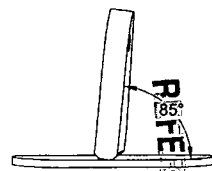
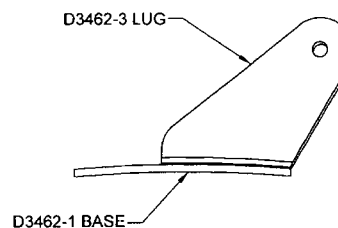
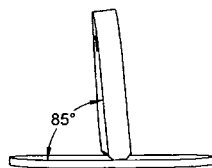
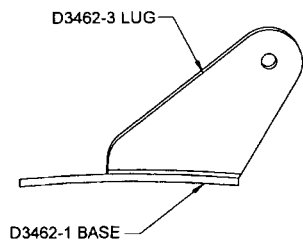
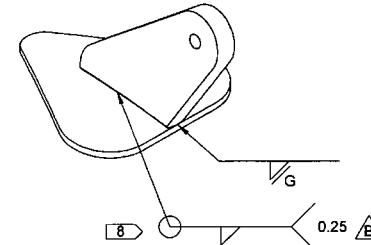
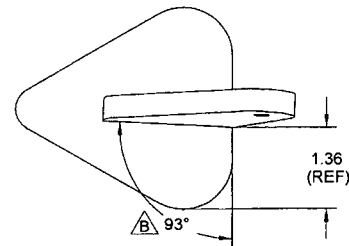
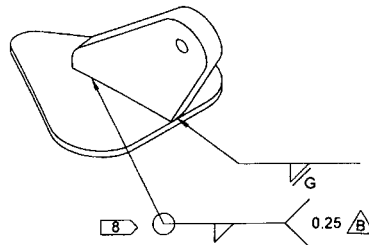
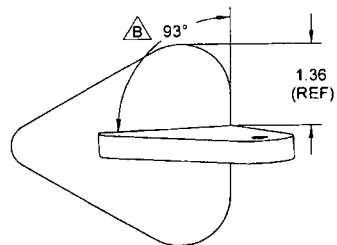
Qty -031	Qty -032	Part Number	Description
X		D412-630-031	PILOT/CO-PILOT STEP, LH (FOLDING)
	X	D412-630-032	PILOT/CO-PILOT STEP, RH (FOLDING)
1	1	D3443-041	STRUT ASSEMBLY
1	1	D3443-043	STRUT ASSEMBLY
2	2	D3443-9	PIN
1	1	D3454-1	BUSHING
2	2	D3454-3	BUSHING
2	2	D3454-5	BUSHING
2	2	D3454-7	BUSHING
6	6	D3455-1 - 2	SPACER
2	2	D3455-3	SPACER
1		D3462-041	BRACKET ASSEMBLY
	1	D3462-042	BRACKET ASSEMBLY
1		D3463-041	STEP ASSEMBLY
	1	D3463-042	STEP ASSEMBLY
1	1	D3465-1	WASHER
2	2	AN310-4	NUT (-1)
2	2	AN310-5	NUT
1	1	AN310-7	NUT
3	3	AN3C-5A	BOLT
1	1	AN44-C12	* EYEBOLT
1	1	AN4C14	BOLT
1	1	AN4C15	BOLT
2	2	AN4CH3	BOLT
1	1	AN5C11	BOLT
1	1	AN5C15	BOLT
7	7	AN960C10	WASHER
1	1	AN960C516	WASHER
3	3	MS21043-3	NUT
2	2	MS24665-227	COTTER PIN (-1)
2	2	MS24665-229	COTTER PIN
1	1	MS24665-302	COTTER PIN
1	1	NAS1515H5	WASHER

* USE AN44-C12 EYEBOLT WHEN D412-630-031/-032 IS INSTALLED IN CONJUNCTION WITH D412-630-023/-024/-033/-034TM HELI-ACCESS-STEP

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Revision: **M**
Date: 08.12.12



D3462-041 BRACKET ASSEMBLY

D3462-042 BRACKET ASSEMBLY

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3462-041	BRACKET ASSEMBLY
	X	D3462-042	BRACKET ASSEMBLY
1	1	D3462-1	BASE
1	1	D3462-3	LUG

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3462-041" OR "D3462-042" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.75 lbs (TYP)
 - 8) WELDING: PER DART QSI 004

C	SHOW VIEWS OF D3462-041 & D3462-042, UPDATE DWG REASON: PRODUCTION FACILITY	DC	07.10.24
B	REVISE DIMENSIONS	RF	05.12.05
A	NEW ISSUE	RF	05.09.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
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DATE	07.10.24		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3462**

TITLE **BRACKET ASSEMBLY**

SCALE 1:2

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